

55551-22

Work Order ID 55551-22

January 20, 2010 11:04:34 AM



Page 1

Item ID: D2492

Revision ID:

Item Name: Patient Stop

Start Date: 1/20/10 Start Qty: 10.00

Required Date: 1/29/10 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2492

Rev F

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2492  
Deburr if necessary

Dwg Rev: F

Prog Rev: f 2-

10-1-21

110

QC2- Inspect parts off machine F/AI/FAB

0.00



QC

Memo

0.00

Quality Control

10-1-21

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

5/10/12

414

Ph

# Work Order ID 55551

January 20, 2010 11:04:34 AM



Item ID: D2492

Accept



Setup Start



Revision ID:

Stop



Item Name: Patient Stop

Start Date: 1/20/10 Start Qty: 10.00



Cust Item ID:

Required Date: 1/29/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



NC BRAKE

0.00

Brake NC

Memo

0.00

SO 110467

(2)

Brake NC

Debur Form using fig D12492B

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8/10/09

(2)

tests on stretches they will  
be sent with

150



Chemical Conversion Coat per QS1005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

2 BR 11-4-8.

Miss Large Fab

BR

# Work Order ID 55551

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Page 3

Item ID: D2492

Accept

Revision ID:

Item Name: Patient Stop

Start Date: 1/20/10 Start Qty: 10.00

Required Date: 1/29/10 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

170

White Gloss(Ref.4.3.5.1) per QS1005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:10

FINISH TIME: 8:40

OVEN TEMPERATURE

180

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

2 of 11 1/10/11

2 BL 11-4-12.

2 of 11 1/10/12.

# Work Order ID 55551

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Item ID: D2492

Accept

Revision ID:

Item Name: Patient Stop

Start Date: 1/20/10 Start Qty: 10.00

Required Date: 1/29/10 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

u/o 68539

0.00

Sp 11/04/15

②

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/15  
MF  
11-04-15

# Picklist Print

January 20, 2010 11:04:33 AM

Page 1

Work Order ID: 55551

Parent Item: D2492

Parent Item Name: Patient Stop

Comments: IPP E 00.06.26 Removed P/O for powder coat EC  
 IPP Rev:F Now 6061-T6 06-06-23 JLM  
 IPP Rev:G now water jet 07-12-11 DD

Start Date: 1/20/10

Required Date: 1/29/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last
M6061T6S.080					
	Purchased		No		

Route	Unit of	Qty on	Remaining	Qty	Date	Status
100	sf	178.9597	19 1884			



6061-T6 .080 Sheet

1810-1-21

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAF	178.95967	
110630	35.0136	
112141	0.86727	
112763	6.85	
113438	136.2288	

13438

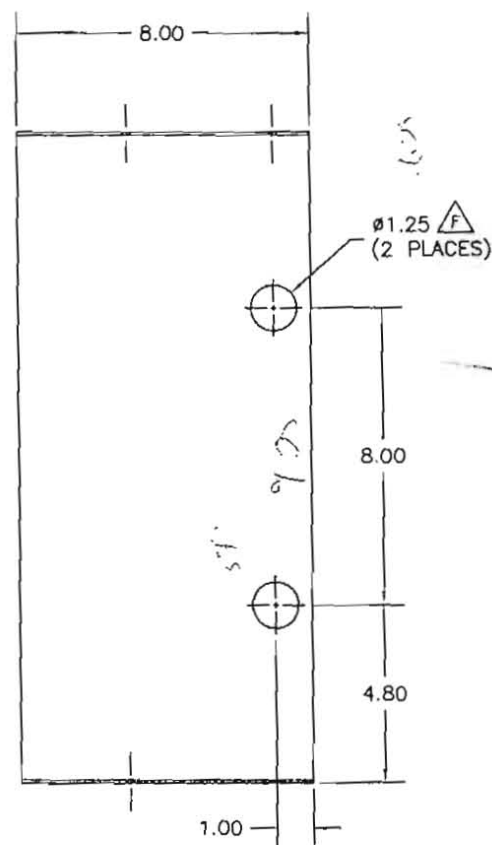
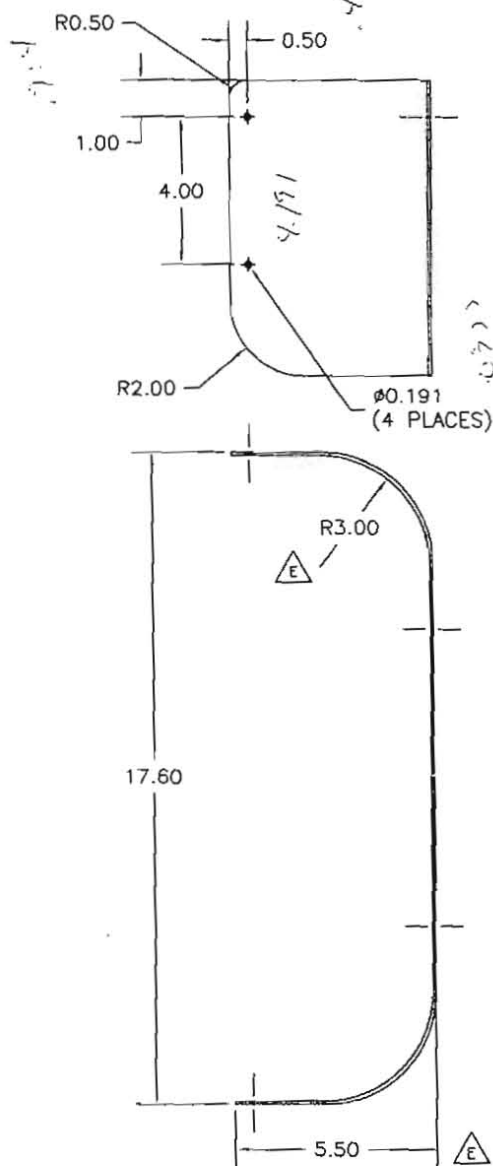
15





**DART**

DESIGN KE	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2492	REV. F SHEET 1 OF 1
DATE 06.09.14	TITLE PATIENT STOP		SCALE 1:5
A	95.10.24	NEW ISSUE	
B	96.02.28	MINOR CHANGES	
C	97.07.14	CHANGED MATERIAL AND FINISH	
D	98.05.11	R4.00 WAS R2.00 ADDED 8" WIDTH DIMENSION	
E	06.05.30	ADD 6061-T6 MATERIAL, R3.0 WAS R4.00, 5.50 WAS 6.00	
F	06.09.14	Ø1.25 WAS Ø1.020	

**D2492 PATIENT STOP**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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## Under Review Notification

Raised By: C Provencal

Date: 10.05.20

Product #: D350-616

Product Name: Litter Kit

Drawing/Kit Number	Drawing/Kit Description	Quantity on Hand (Stock)	Quantity on Order (Production)	Quantity Allocated (Customer Order)	HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise customers	Stop Production	Re-Work Stock	IPP Under Review	Blue File Under Review	ECN #	Instructions
D2492	Patient Stop				N	Y	N	Y	Y	Y	Y	10-577	Quarantine stock, rework per instruction
D2493	Patient Stop Assembly				N	Y	N	Y	Y	Y	Y	10-577	below, OK to ship after rework.
D315-616-011	Full Litter Kit				N	Y	N	N	Y	Y	Y	10-577	Get ENG sign off to produce more, with
													hole removed.

### Description of issue:

- Location of holes in litter kit for installation of patient stop has no consistency between batches.
- Lower hole from D2492 Patient Stop will be removed. As part of assembling litter kit, patient stop will be drilled to match litter. For replacement parts, customer will transfer drill patient stop to fit litter.
- Rework existing stock of D2492/D2493 patient stops to remove lower hole. Any patient stops already in kits that fit their litter are OK as-is.
- Ensure for any D315-616-011 in stock that the patient stop fits the litter.

### Distribution:

General Manager  
Production Manager  
Director Quality Assurance  
Design Manager  
Chief Engineer

Production Engineering Coordinators  
Quality Assurance Coordinator  
Quality Control Coordinator  
Order Processing  
Customer Technical Support

Engineering Project Managers  
Engineering Clerk  
Marketing